

Date: Tuesday, 4/4/2006 1:32:28 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 26512		
Estimate Number	: 10531		
P.O. Number	: N/A	Part Number	: D2572
This Issue	: 4/4/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2572 REV E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25997	Drawing Revision	: E
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>SEE COMMENT REKW</u>	Due Date	: 4/30/2006
Checked & Approved By	: <u>06.04.04</u>	Qty:	8 Um: Each
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2572
Ensure that grain is along 5.00" length
Batch No: 824069

S.G. 06105107

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 826512 Double check by: SA

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove shap edges.

S.G. 06105107

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

S.G. 06105111

8

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/05/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:32:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 26512

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

CP/S.G

06/05/12

8

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS

06/05/15

8

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06/05/16

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m - 06-05-16

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AL

06/05/16

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST479

AL

06/05/16

(8)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D

06/05/17

(8)

Job Completion



u 06/05/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 26512
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.746	1.747	1.746	1.746		
C	3.495	3.505		3.498	3.497	3.497	3.498		
D	1.745	1.755		1.746	1.747	1.746	1.747		
E	7.990	8.010		8.004	8.000	8.005	8.001		
F	0.490	0.510		0.497	0.497	0.501	0.501		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.259		
H	0.375	0.380	DT8684	0.377	0.376	0.376	0.376		
I	0.490	0.510		0.493	0.495	0.497	0.498		
J	1.174	1.184		1.178	1.177	1.177	1.176		
K	0.558	0.578		0.566	0.563	0.568	0.567		
L	1.174	1.184		1.178	1.177	1.177	1.176		
M	1.490	1.500		1.493	1.495	1.498	1.499		
N	2.495	2.505		2.497	2.496	2.499	2.497		
O	3.869	3.879		3.872	3.874	3.874	3.873		
P	0.115	0.135		0.124	0.130	0.125	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.260	0.260	0.250	0.249		
S	0.115	0.135		0.125	0.122	0.123	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.966	2.960		
V	0.230	0.250		0.240	0.240	0.245	0.246		
W	0.115	0.135		0.126	0.126	0.120	0.121		
X	0.307	0.312		0.309	0.310	0.308	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.367	0.360	0.359		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.622	0.622	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.253	0.248	0.247	0.248		
AE	1.375	1.395		1.383	1.384	1.381	1.381		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.258	0.256	0.255	0.249		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	Ed / S.G
Date:	06/05/11

Audited by:	M8
Date:	06/05/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	26512
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.747	1.747	1.749	1.749		
C	3.495	3.505		3.499	3.498	3.498	3.499		
D	1.745	1.755		1.747	1.746	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.000		
F	0.490	0.510		0.501	0.498	0.501	0.502		
G	0.257	0.262	DT8683	0.259	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.501	0.502	0.498	0.500		
J	1.174	1.184		1.179	1.176	1.180	1.179		
K	0.558	0.578		0.560	0.561	0.569	0.568		
L	1.174	1.184		1.179	1.176	1.179	1.179		
M	1.490	1.500		1.497	1.497	1.499	1.499		
N	2.495	2.505		2.499	2.498	2.502	2.501		
O	3.869	3.879		3.872	3.873	3.872	3.871		
P	0.115	0.135		0.125	0.121	0.121	0.120		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.247	0.246	0.246	0.245		
S	0.115	0.135		0.130	0.129	0.129	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.961	2.959	2.959		
V	0.230	0.250		0.249	0.247	0.248	0.247		
W	0.115	0.135		0.119	0.127	0.130	0.130		
X	0.307	0.312		0.311	0.310	0.308	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.364	0.364	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.631	0.622	0.621	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.248	0.249	0.248		
AE	1.375	1.395		1.382	1.381	1.381	1.381		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.254	0.253	0.252	0.251		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP / J.G.
Date:	06/05/11

Audited by:	MS
Date:	06/05/15

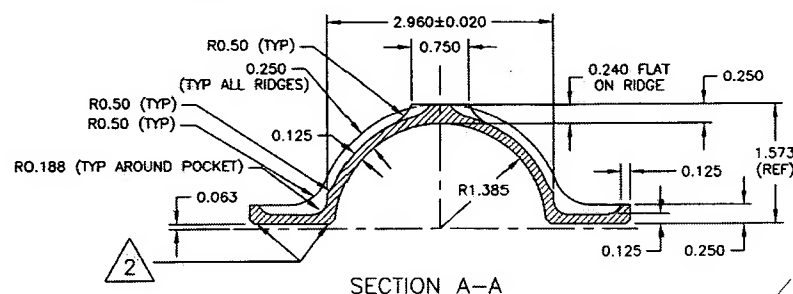
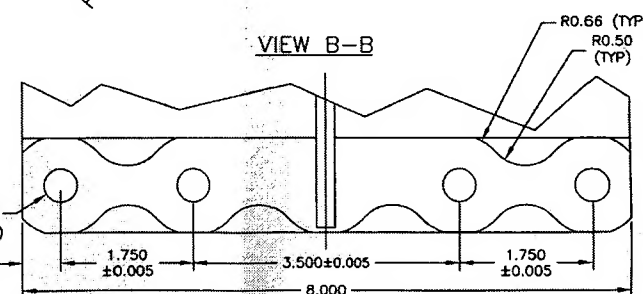
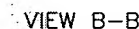
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

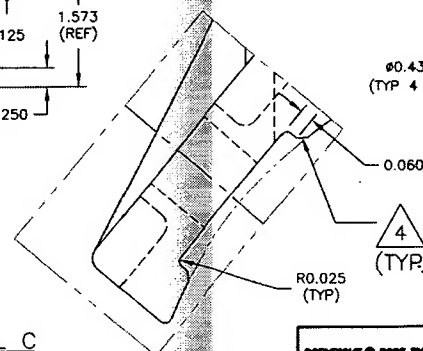





MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



DETAIL C
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
		DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2572
DATE 05.07.13		TITLE INNER FWD SADDLE
		SCALE

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DART AEROSPACE LTD.

DART DART AEROSPACE LTD.
HAMPSHIRE, ONTARIO, CANADA

DRAWING NO.	REV. B
D2572	SHEET 1 OF 1
TITLE	SCALE
INNER FWD SADDLE	2:3

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